

Table for PP



Foundation: 2207, 2208 DIN 16932 German association for welding

Use for: **4600 / 4502** OD 75 - 250

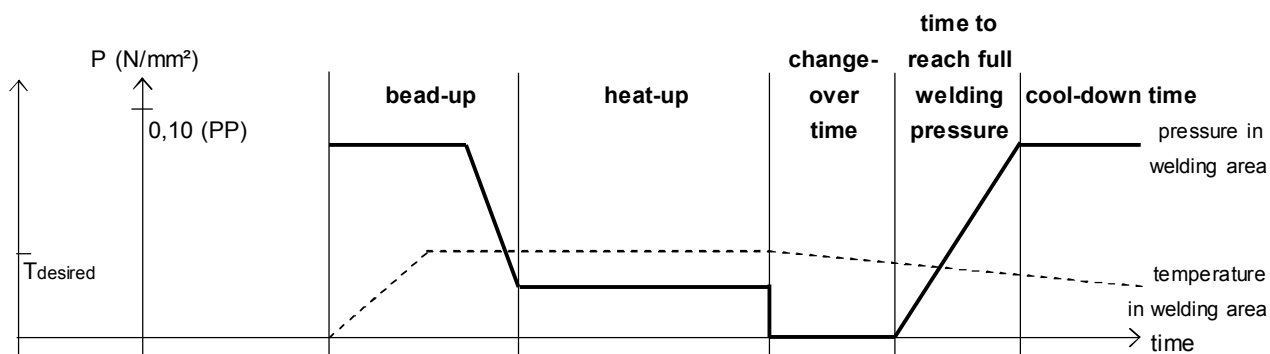
4800 / 4702 OD 90 - 315

1 bar on manometer: **52 N**

The standard value for heating element temperature is 210° C +/- 10° C.

The **smaller** the pipe wall the **higher** the temperature.

Additional to the given bead-up force and to the welding force the moving force of the support must be added !



pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min]
75	1,9	41	1	0,5	90	4	5	1	2
	2,3	33	2	0,5	95	4	5	2	2
	2,9	26	2	0,5	106	4	5	2	3
	4,3	17,6	2	0,5	131	5	6	2	6
	6,8	11	3	0,5	172	6	7	3	12
	10,3	7,4	5	1,0	221	7	10	5	17
	12,5	6	5	1,0	251	7	11	5	21
90	2,2	41	2	0,5	94	4	5	2	2
	2,8	33	2	0,5	104	4	5	2	3
	3,5	26	2	0,5	117	5	6	2	4
	5,1	17,6	3	0,5	145	5	6	3	7
	8,2	11	5	1,0	192	6	8	5	14
	12,3	7,4	6	1,0	249	7	11	6	20
	15,0	6	7	1,0	281	8	14	7	24
110	2,7	41	2	0,5	103	4	5	2	3
	3,4	33	3	0,5	115	5	6	3	4
	4,2	26	3	0,5	130	5	6	3	6
	6,3	17,6	4	0,5	164	6	7	4	10
	10,0	11	7	1,0	217	7	9	7	17
	15,1	7,4	9	1,0	283	8	14	9	24
	18,3	6	11	1,0	322	9	16	11	29

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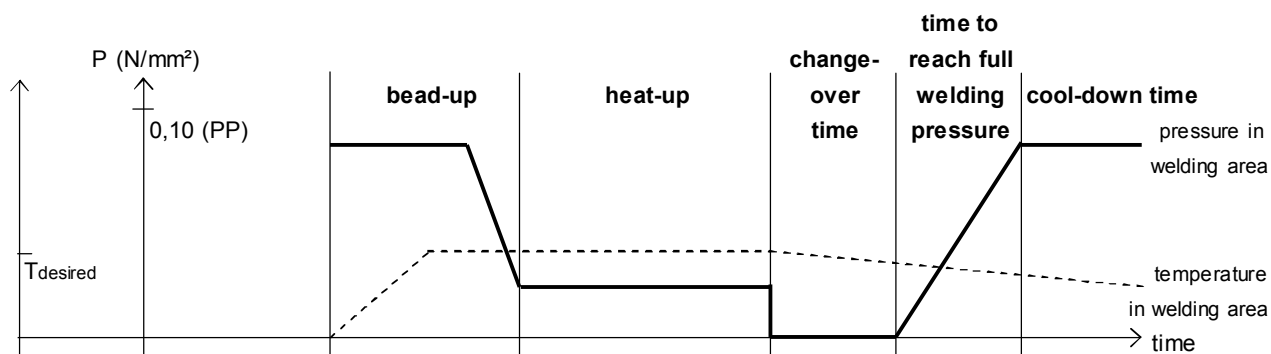
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125	3,1	41	3	0,5	110	4	5	3	4
	3,9	33	3	0,5	124	5	6	3	5
	4,8	26	4	0,5	140	5	6	4	7
	7,1	17,6	6	1,0	176	6	7	6	12
	11,4	11	8	1,0	237	7	11	8	19
	17,1	7,4	12	1,0	307	8	15	12	27
	20,8	6	14	1,5	348	10	18	14	33
140	3,5	41	3	0,5	117	5	6	3	4
	4,3	33	4	0,5	131	5	6	4	6
	5,4	26	5	0,5	149	5	6	5	8
	8,0	17,6	7	1,0	189	6	8	7	14
	12,7	11	10	1,0	254	7	12	10	21
	19,2	7,4	15	1,5	332	9	17	15	30
	23,3	6	17	1,5	373	10	20	17	36
160	4,0	41	4	0,5	126	5	6	4	5
	4,9	33	5	0,5	141	5	6	5	7
	6,2	26	6	0,5	162	6	7	6	10
	9,1	17,6	9	1,0	204	6	9	9	15
	14,6	11	13	1,0	277	8	13	13	24
	21,9	7,4	19	1,5	359	10	19	19	34
	26,6	6	22	2,0	405	11	23	22	41

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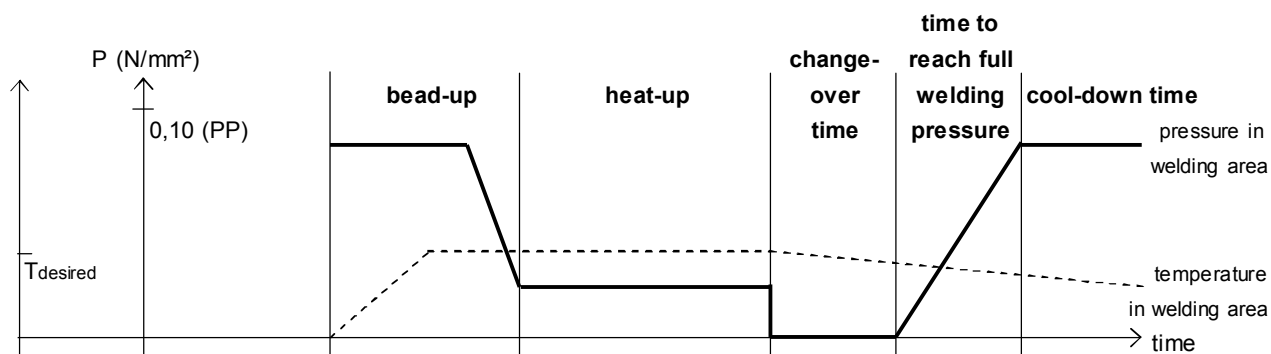
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180	4,4	41	5	0,5	133	5	6	5	6
	5,5	33	6	0,5	151	5	6	6	8
	6,9	26	8	0,5	173	6	7	8	12
	10,2	17,6	11	1,0	220	7	10	11	17
	16,4	11	17	1,0	298	8	15	17	26
	24,6	7,4	24	1,5	386	11	21	24	38
	29,0	6	27	2,0	423	12	25	27	44
200	4,9	41	6	0,5	141	5	6	6	7
	6,2	33	8	0,5	162	6	7	8	10
	7,7	26	9	1,0	185	6	8	9	13
	11,4	17,6	13	1,0	237	7	11	13	19
	18,2	11	20	1,0	320	9	16	20	29
	27,4	7,4	29	2,0	411	11	23	29	42
	33,2	6	34	2,0	456	13	29	34	50
225	5,5	41	8	0,5	151	5	6	8	8
	6,9	33	10	0,5	173	6	7	10	12
	8,6	26	12	1,0	197	6	8	12	15
	12,8	17,6	17	1,0	255	7	12	17	21
	20,5	11	26	1,5	345	9	18	26	32
	30,8	7,4	37	2,0	437	12	26	37	47
	37,4	6	43	2,5	487	14	32	43	55
250	6,2	41	10	0,5	162	6	7	10	10
	7,7	33	12	1,0	185	6	8	12	13
	9,6	26	14	1,0	211	7	9	14	16
	14,2	17,6	21	1,0	272	8	13	21	23
	22,7	11	32	1,5	367	10	20	32	35
	34,2	7,4	45	2,0	463	13	29	45	51

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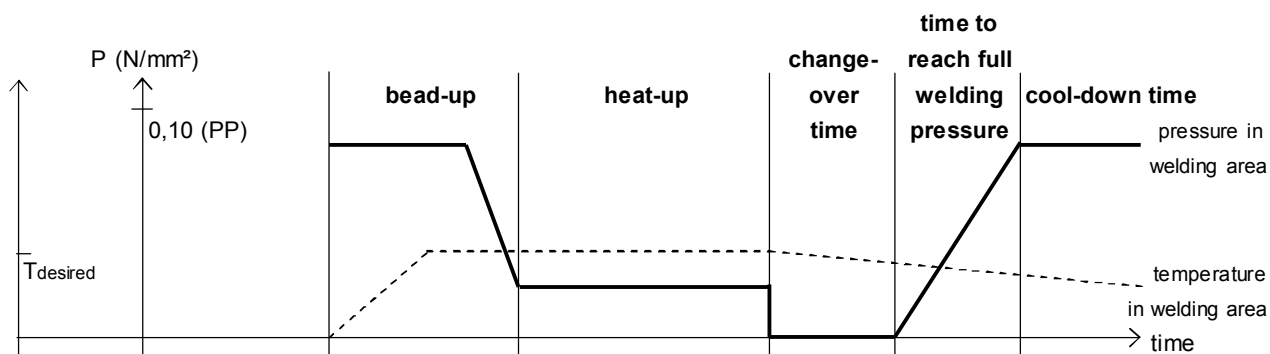
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280	6,9	41	12	0,5	173	6	7	12	12
	8,6	33	15	1,0	197	6	8	15	15
	10,7	26	18	1,0	227	7	10	18	18
	15,9	17,6	26	1,0	292	8	14	26	26
	25,4	11	40	1,5	394	11	22	40	39
	38,3	7,4	56	2,5	493	14	33	56	57
315	7,7	41	15	1,0	185	6	8	15	13
	9,7	33	18	1,0	213	7	9	18	16
	12,1	26	23	1,0	246	7	11	23	20
	17,9	17,6	33	1,0	317	9	16	33	28
	28,6	11	50	2,0	420	12	24	50	44

① Remaining under the cool-down time for up to 50% is allowed under the following conditions:

- prefabrication under workshop conditions
- low additional pressure at unclamping
- no additional pressure during further cooling down
- load onto the workpieces only after being completely cooled down